

Work Order ID 75960

\*75960\*

~~U/R~~

Page 1

Item ID: D3391-025

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Aft Tube Assembly

Stop \*NS2\*

Start Date: 02/11/2011 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 16/11/2011 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: M.C.J. Date: 11/11/02 Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp: Stamp
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Draw Nbr

Revision Nbr

D3391

Rev H U/R/ DEO

100

0.00

\*100\*

MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

Turn as per Folio FA599 - Rev: I &amp; Dwg D3391 Rev: I

\*\*\*scribe batch # on fwd end at 90 degree\*\*\*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

111

QC8- Inspect parts - second check

0.00

\*111\*

QC

Memo

0.00

Quality Control

1 Ø

mm-L 11/11/14

1 Ø

mm-L 11/11/14

11.11.21

1 Ø

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75960

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November-02-11 10:41:18 AM

Item ID: D3391-025 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Tube Assembly  
 Start Date: 02/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 16/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> HAAS I HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1  Memo 1-Machine as per Folio FA 599 Rev: <u>AA</u> & Dwg D3391 Rev: <u>I</u> 2-Deburr	0.00  0.00	<i>BC</i>	<i>11/11/19</i>	<i>1</i>	<i>0</i>			
130 <b>*130*</b> QC Quality Control	QC2- Inspect parts off machine FAI/FAIB  Memo	0.00  0.00	<i>EL</i>	<i>11/11/19</i>	<i>1</i>	<i>0</i>			
140 <b>*140*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00	<i>RP</i>	<i>11-11-21</i>	<i>1</i>	<i>0</i>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**\*75960\***

November-02-11 10:41:18 AM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Cust Item ID:**

**\* 1 \***

**\* 1 \***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

150

**\*150\***

## Skidtubes

## Skidtubes

## Skidtubes

## Memo

1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

0.00.

.00

160

**\*160\***

CNC Bend 1

## CNC Delta 100 Bender

## BENDING MACHINE - SKIDTUBES

## Memo

Form as per Dwg D3391 Using Bend Prog 3391025

0.00

0.00

170.

**\*170\***

QC

## Quality Control

QC5- Inspect part completeness to step on W/O

## Memo

0.00

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod.Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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November 02-11 10:41:18 AM

Item ID: D3391-025  
Revision ID:  
Item Name: Aft Tube Assembly

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Start Date: 02/11/2011 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 16/11/2011 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

**\*180\***

Skidtubes

Skidtubes

0.00

Memo

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only)

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.250" and c'bore as per dwg D3391

6-Open up all wearshoe, wearplate to 0.297" and float bag holes to 0.328" as per Dwg D3391.

7-Deburr

*3* *OK 11/11/23*

*3* *OK 11/11/24*

*DP 11-12-13*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial, Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 02/11/2011    **Start Qty:** 1.00    **\*1\***

**Cust Item ID:**

**Required Date:** 16/11/2011      **Req'd Qty:** 1.00      **\* 1 \***

**Customer:**

Run Start \*NR1\*

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

**Insp.  
Stamp**

0.00

**\*190\***

QC

## Memo

0.00

## Quality Control

0.00

**\*200\***

HandFinish

## Memo

0.00

## Hand Finishing

0.00

**\*210\***

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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# Work Order ID 75960

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November-02-11 10:41:18 AM

Item ID: D3391-025 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Tube Assembly  
 Start Date: 02/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 16/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Skidtubes	0.00							
<b>*220*</b>									
Skidtubes	Memo	0.00							
Skidtubes	Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <u>M117870</u> exp. date: <u>03/2017</u> cure time 12hrs as per QSI0015								
230	QC5- Inspect part completeness to step on W/O	0.00							
<b>*230*</b>									
QC	Memo	0.00							
Quality Control									
235	Pressure Wash per QSI005 4.3	0.00							
<b>*235*</b>									
HandFinish	Memo	0.00							
Hand Finishing	AND REALODINE AS PER PAR09-043								

SAD 11-12-13

S 11/21/16

CF/DP 11-12-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75960

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November-02-11 10:41:18 AM

Item ID: D3391-025 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Tube Assembly  
 Start Date: 02/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 16/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
240	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*240*</b> Powdercoat Powder Coating	Memo START TIME: <u>8:30</u> OVEN TEMPERATURE: <u>320</u> °F FINISH TIME: <u>9:00</u>	0.00							<u>1/12/17</u>
250	QC3- Inspect Part Finish	0.00							
<b>*250*</b> QC Quality Control	Memo	0.00							<u>1/12/19</u>
260	HandFinishing	0.00							
<b>*260*</b> HandFinish Hand Finishing	Memo ✓ 1-Install inserts as per Dwg D3391 2-Install Aft Cap as per Dwg D3391 ✓ A/R Sikaflex-241/-291 <u>1119443</u> Sikaflex expiry date: <u>12/15</u>	0.00							<u>1/12/19</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 75960

**\*75960\***

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November-02-11 10:41:18 AM

Item ID: D3391-025 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Tube Assembly  
 Start Date: 02/11/2011 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 16/11/2011 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270 <b>*270*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		8 11/2/19					
280 <b>*280*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>W/O</u>  Memo	0.00 0.00		D 412-742-043/B75909		21	22	4/12/19	
290 <b>*290*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							11/2/19 NE 11-12-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 1

Work Order ID: 75960

**\*75960\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 1.00

Required Qty: 1.00

## Comments:

IPP Rev B 06-02-07 ECN773 dwg rev. D EC  
 IPP Rev:C 06-03-28 Update Manuf. Instructions JLM  
 IPP rev D 07.03.20 revF dwg EC  
 IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD  
 IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC  
 IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6014-090 Manufactured No

100

Each

23,0000

1

1

**\*D6014-090\***

ALUMINUM EXTRUSION

\*\*

### Location

### Loc Qty

### Loc Code

LG

23

66179

23

D3670-4-200

Manufactured No

230

Each

128.0000

4

4

**\*D3670-4-200\***

SPACER

\*\*

### Location

### Loc Qty

### Loc Code

LG

36

71850

36

LG001

92

72851

92

mm L 11/11/09

SAD 12/27/13

4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75960

**\*75960\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2646 Manufactured No

270 Each 73.0000 1 1

**\*D2646\***

Aft Cap

\*\*

B73825 (x1) M 11/12/11

## Location

## Loc Qty

## Loc Code

FP002	56
73294	56
FP004	5
68280	5
FP006	5
62678	5
FP-4	3
70945	1
71070	2
fp5	4
71038	4

D3537-1

Manufactured No

270 Each 108.0000 1 1

**\*D3537-1\***

Wearpad

\*\*

B77436 (x1) M 11/12/11

## Location

## Loc Qty

## Loc Code

FP002	101
74436	70
74597	31
FP017	7
69817	5
70686	2

D4095-049

OK P 11/12/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75960

**\*75960\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3537-7

Manufactured No

270

Each

9.0000

1

1

**\*D3537-7\***

Wearpad

\*\*

1376537 (x1) 11/11/11

D4095-047

Location

Loc Qty

Loc Code

FP

4

71689

4

FP017

5

71689

5

D3553-1

Manufactured No

270

Each

37.0000

1

1

**\*D3553-1\***

Gasket

\*\*

N/A

N/A 11.12.11

Location

Loc Qty

Loc Code

FP013

37

56568

2

73155

35

D3553-3

Manufactured No

270

Each

22.0000

1

1

**\*D3553-3\***

Gasket

\*\*

N/A

N/A 11.12.11

Location

Loc Qty

Loc Code

FP

20

31631

20

FP013

2

53480

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 75960

**\*75960\***

Parent Item: D3391-025

**\*D3391-025\***

Parent Item Name: Aft Tube Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-1 Manufactured No

270

Each

696.0000

2

2

**\*D3672-1\***

Phenolic Washer

\*\*

HL 11/12/14

Location

Loc Qty

Loc Code

FP-A

432

52505

0

66821

432

XZ

ST074

264

72229

264

ALS4-1032-130

Purchased

No

260

Each

2,279.000

14

14

**\*AI S4-1032-130\***

Insert

\*\*

M 119350 X 14 HL 11/12/14

Location

Loc Qty

Loc Code

ST280

2000

119084

2000

ST281

279

117717

2

118237

12

118312

2

118386

263

ALS4-1032-225

Purchased

No

270

Each

2,422.000

12

12

**\*AI S4-1032-225\***

Insert

\*\*

HL 11/12/14

Location

Loc Qty

Loc Code

ST281

2422

108696

502

110768

62

118386

858

118966

1000

XZ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

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Page 5

Work Order ID: 75960

\*75960\*

Parent Item: D3391-025

\*D3391-025\*

Parent Item Name: Aft Tube Assembly

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C4A

Purchased

No

270

Each

2,385.000

6

6

\*AN3C4A\*

BOLT

\*\*

11/12/19

## Location

## Loc Qty

## Loc Code

ST350

2385

117313

2

117688

5

117872

22

118112

16

118451

2

118706

364

118838

974

119328

1000

X6

AN3C5A

Purchased

No

270

Each

1,131.000

4

4

\*AN3C5A\*

Bolt

\*\*

11/19/744 (x4) 11/12/19

## Location

## Loc Qty

## Loc Code

FP-A

7

115835

7

ST350

1124

116419

28

117343

17

117764

166

117872

2

118451

411

119127

500

AN960C10L

NAS1149C0332

Purchased

No

270

Each

0.0000

10

10

\*AN960C10I \*

washer

\*\*

11/19/736 (x10) 11/12/19

November-02-11 10:41:22 AM

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 75960
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> D3391-3
<b>Inspection Dwg:</b> D3391- Rev: H		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<b>Lathe Section</b>						
14.000	+/-0.010	14.00	✓		tape	MTR, C - 20
3.500	+/-0.010	3.500	✓		vern	CWC - 08
88.93	+/-0.030	88.93	✓		tape	MTR, L - 08
Ø3.200	+/-0.010	3.201	✓		vern	CWC - 08
88.93	+/-0.030	88.93	✓		tape	MTR, L - 02
Ø3.750	+/-0.010	3.750	✓		vern	CWC - 08
30° x 160° chamfer	+/-0.010	30° x 160	✓		ll	

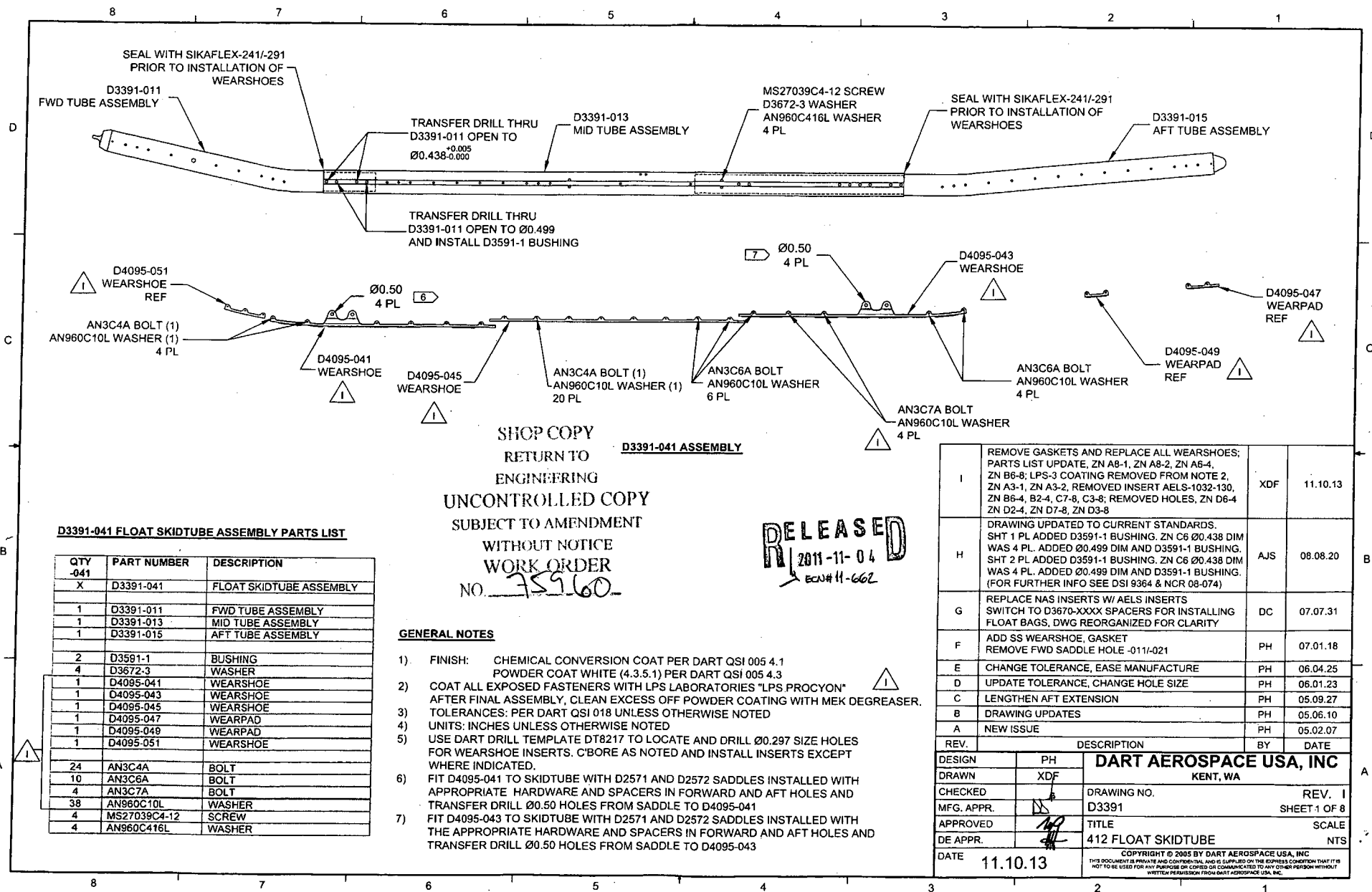
<b>Measured by:</b> MTR, C	<b>Date:</b> 11/11/10
<b>Audited by:</b> RG	<b>Date:</b> 11.11.21

<b>HAAS Section</b>						
1.526	+0.000/-0.030	1.509	✓		Vern	JLM 06
7.500	+/-0.010	7.500	✓			
27.750	+/-0.010	27.750	✓			
31.750	+/-0.010	31.750	✓			
35.250	+/-0.010	35.250	✓			
3.300	+/-0.010	3.302	✓			
0.200	+/-0.010	.200	✓			
3.520	+/-0.010	3.525	✓			
0.687	+0.010/-0.000	.690	✓			
R0.062	+/-0.010	.062	✓			
Ø0.484	+0.005/-0.001	.484	✓			

<b>Measured by:</b> RG	<b>Date:</b> 11.11.19
<b>Audited by:</b> RG	<b>Date:</b> 11.11.21

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue P/O D3391-015/-025	KJ/JLM	
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	





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WORK ORDER  
NO. 75960

D3391-041 ASSEMBLY

D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"  
AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.
- 6) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 7) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH  
THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND  
TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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ECN# 11-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A6-4, ZN B6-8; LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	XDF		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.10.13		

DART AEROSPACE USA, INC  
KENT, WA

DRAWING NO. REV. 1  
D3391 SHEET 1 OF 8  
TITLE SCALE  
412 FLOAT SKIDTUBE NTS

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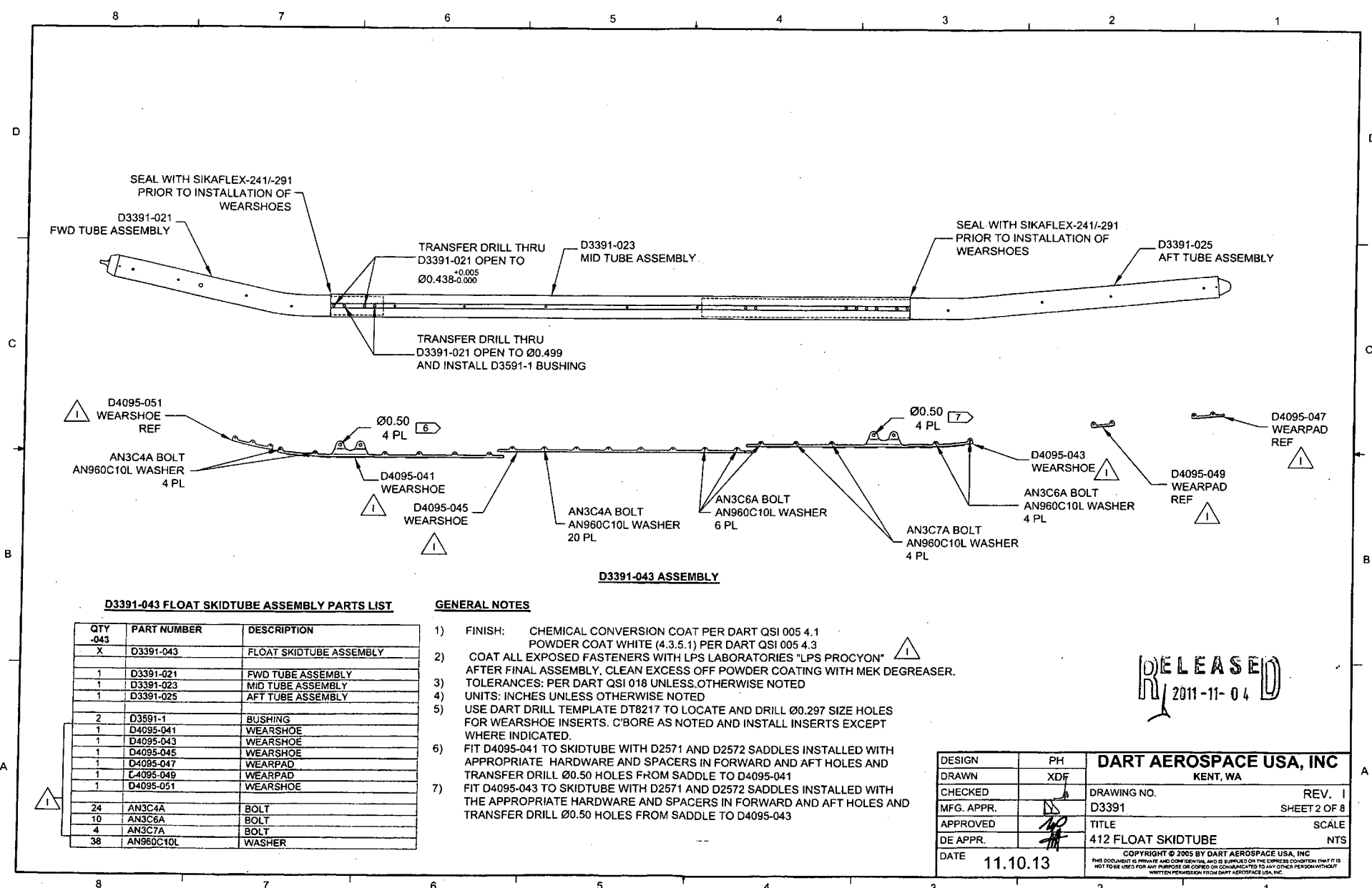
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

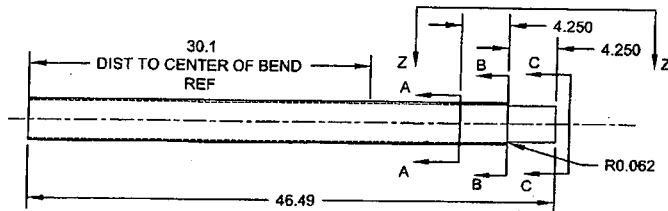
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

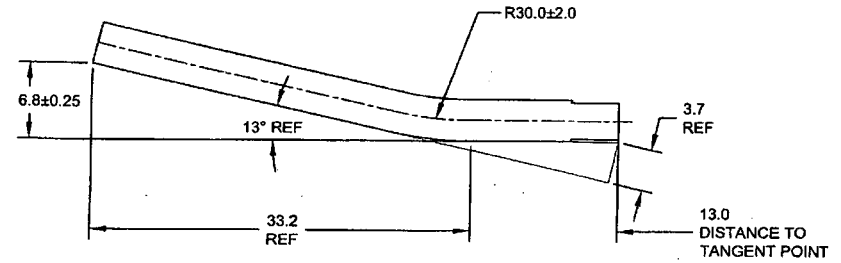
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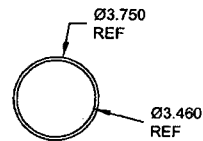
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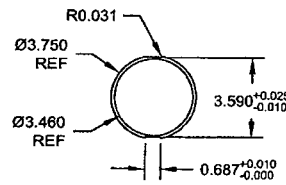
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(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



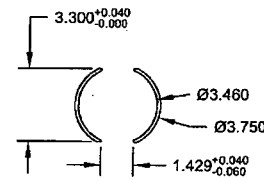
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



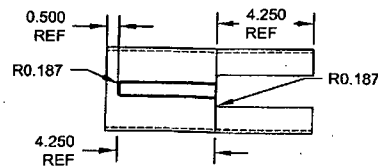
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**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



**VIEW Z-Z**  
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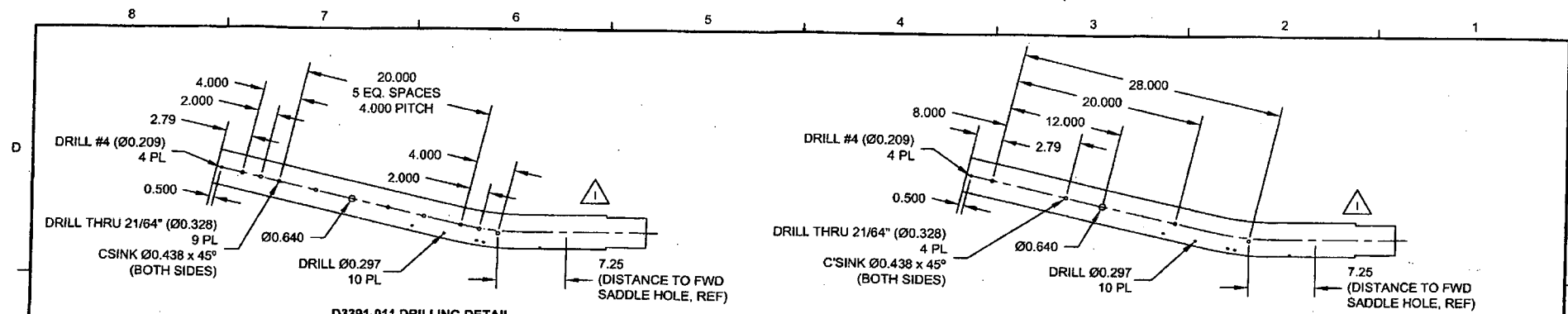
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

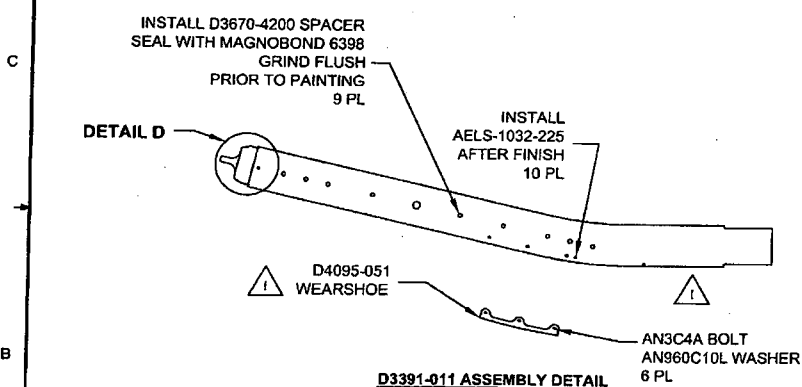
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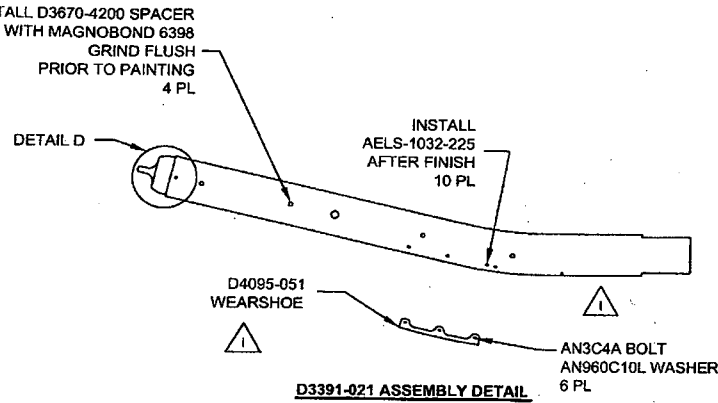


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**D3391-021 DRILLING DETAIL**



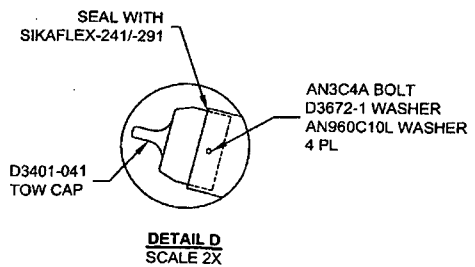
**D3391-011 ASSEMBLY DETAIL**



**D3391-021 ASSEMBLY DETAIL**

**D3391-011/-021 FWD TUBE ASSEMBLY PARTS LIST**

QTY - 011	QTY - 021	PART NUMBER	DESCRIPTION
X		D3391-011	FWD TUBE ASSEMBLY
	X	D3391-021	FWD TUBE ASSEMBLY
1	1	D3401-041	TOW CAP
9	4	D3670-4200	SPACER
4	4	D3672-1	WASHER
1	1	D4095-051	WEARSHOE
1	1	D6013-047	FWD TUBE
10	10	AN3C4A	BOLT
10	10	AN960C10L	WASHER
10	10	AELS-1032-225	INSERT



**DETAIL D  
SCALE 2X**

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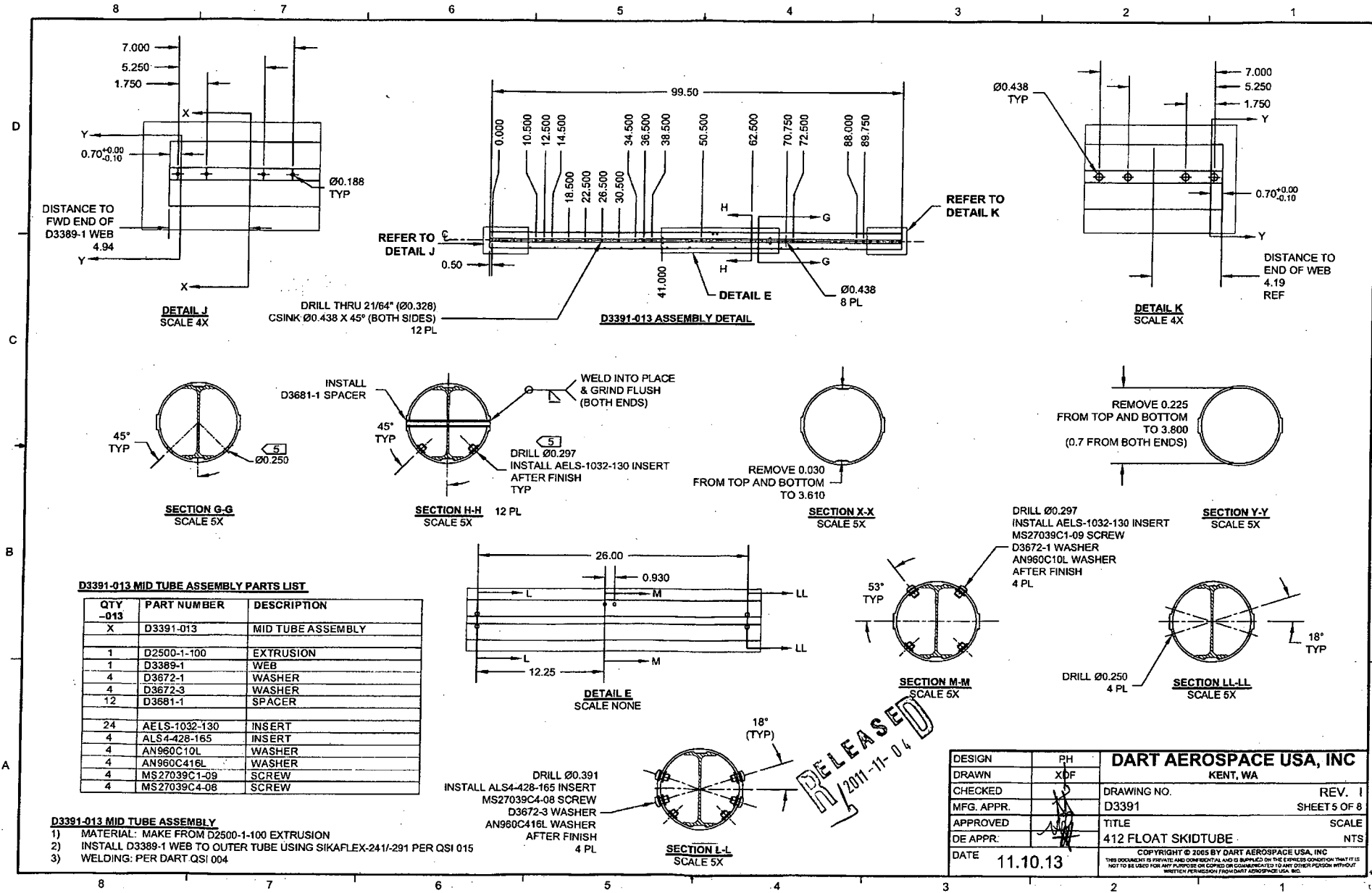
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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W/O:		WORK ORDER CHANGES					
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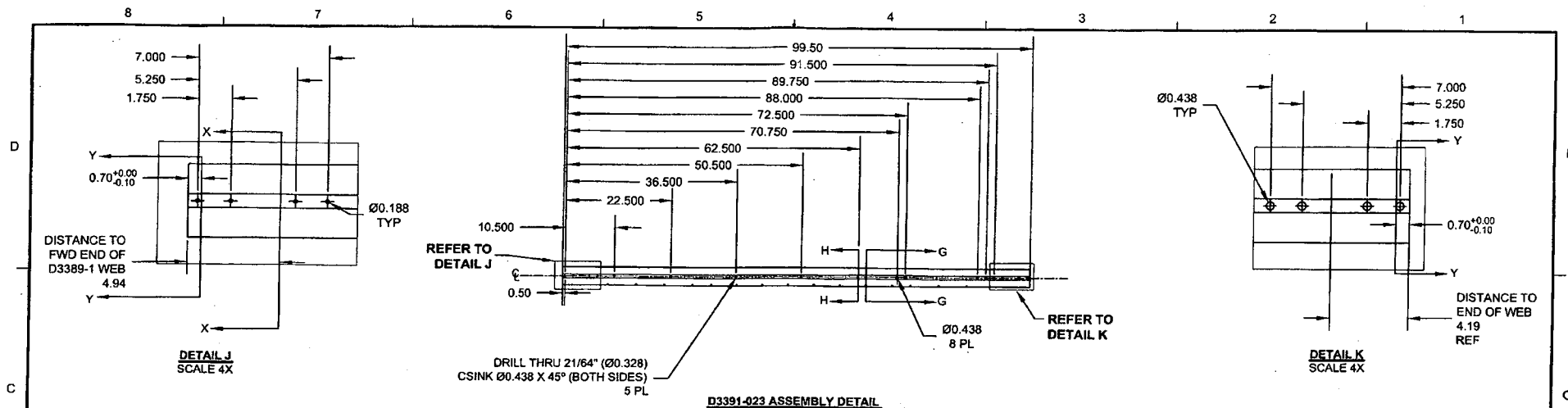
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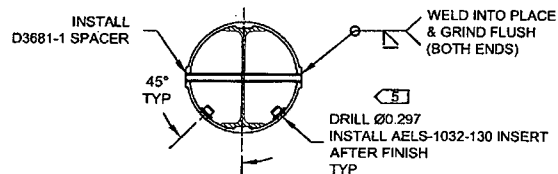
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

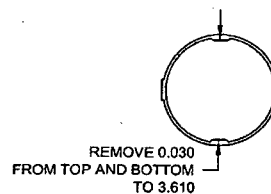
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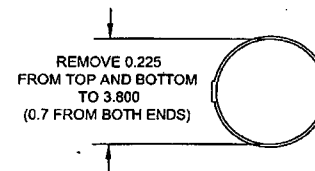
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SCALE 5X



SECTION H-H  
SCALE 5X



SECTION X-X  
SCALE 5X



SECTION Y-Y  
SCALE 5X

**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

**D3391-023 MID TUBE ASSEMBLY**

- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
- 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015
- 3) WELDING: PER DART QSI 004

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

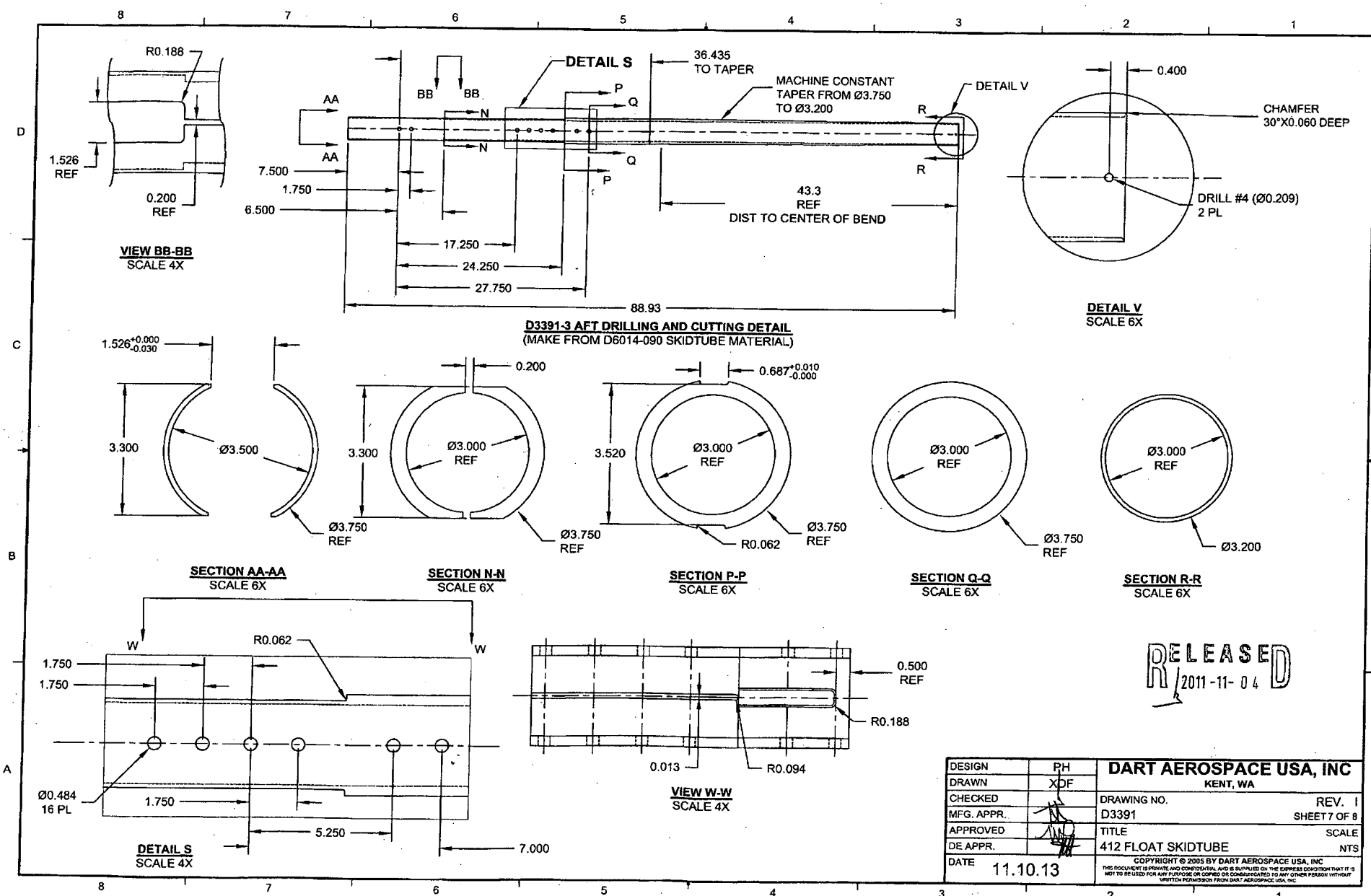
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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RELEASED  
2011-11-04

DESIGN	RH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	XDF	KENT, WA	
CHECKED		DRAWING NO.	REV. I
MFG. APPR.		D3391	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	11.10.13	<small>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

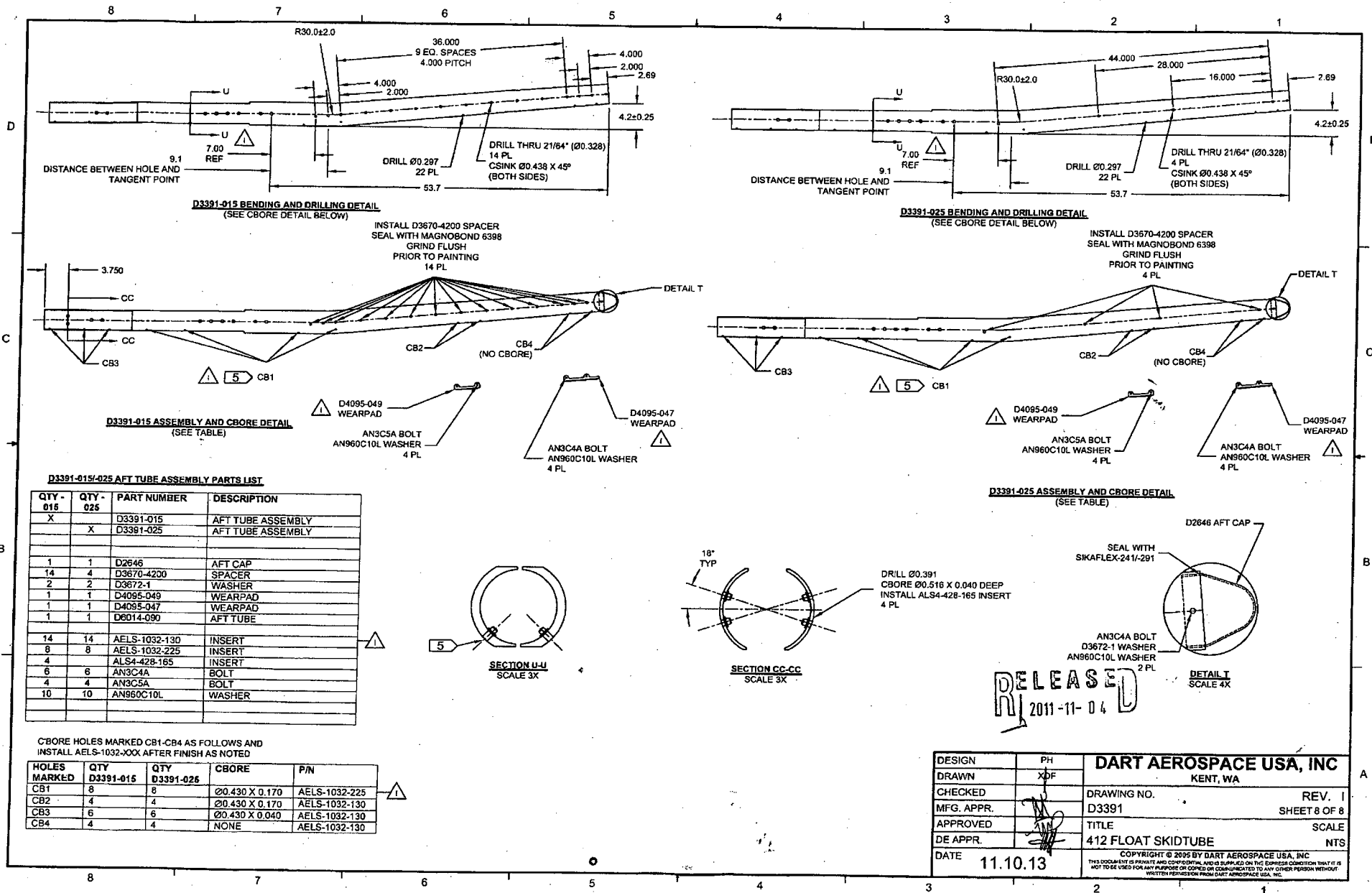
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

75960



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries